

**ABSTRACT OF THE DISCLOSURE**

An improved apparatus used in press brakes having a lower  
5 press member and an upper press member which are movable relative  
toward and away from each other for bending and forming sheet  
materials is provided. The apparatus includes a die base, first and  
second mobile carrier shoes, a plurality of spacer bars, and a pair  
of anvils. Each one of the pair of anvils is formed with four  
10 corners each having a separate and distinct radius of curvature so  
as to define four alternative forming surfaces. Each one of the  
anvils are selectively rotatable so that one of the four corners  
having the same radius of curvatures are on top and facing inwardly  
toward the other corresponding to first through fourth ones of the  
15 four alternative forming surfaces and forming first through fourth  
die-size openings therebetween used for bending and forming a  
material of different predetermined gauges. As a result, multiple  
bending operations with different gauges of sheet material can be  
achieved without changing completely to a different lower die.